

BLUE

Dart Aerospace Ltd.

Date: Thursday, 6/21/2007 2:27:05 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/0H-58 SADDLE, OUTBOARD, LEFT SIDE	
Job Number	: 33032		Part Number	: D29321 <i>W</i>	
Estimate Number	: 10831		Drawing Number	: D2932 REV C	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/21/2007 S.O. No. : N/A		Drawing Revision	: C	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/28/2007	
Previous Run	: 32377		Qty:	8 Um: Each	
Written By	: <i>JK</i>				
Checked & Approved By	: <i>JK</i> 07.06.22				
Comment	: Est: B 00/06.26 New DWG rev, (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D6101003	7075-T7351 2X6.25X7.875	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length Batch No: <i>B31387</i>			
2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1			
Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr & TUMBLE <i>JK/SD 05.01.07</i>			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <i>JK/SD 05.07.07</i>			
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
Comment: INSPECT ALL DIM TO DIM SHEET <i>JK/SD 05.07.07</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:27:05 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/0H-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 33032

Part Number: D29321

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



JL 07/07/08

Comment: SECOND CHECK

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

07.07.12

8

7.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

- PRIME
- PAINT DELFLEET BLUE
- CLEAR DELFLEET

8.0 QC14 INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

stock unpriced (8)

07/07/12 (8) UP

8

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/12 (8)

Job Completion



07.07.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	33032
Description: 206 Saddle, Outboard, Left side				Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.126	0.129	.129	.128		
B	0.100	0.140		0.130	0.127	.130	.129		
C	0.100	0.140		0.118	0.119	.122	.123		
D	0.210	0.230		0.224	0.224	.224	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	.510	.510	.510		
I	1.572	1.582		1.576	1.576	1.577	1.577		
J	2.495	2.505		2.499	2.499	2.499	2.500		
K	0.257	0.262		0.258	0.258	.258	.258		
L	0.312	0.317		0.315	.314	.314	.314		
M	0.235	0.240		0.239	.239	.239	.239		
N	0.100	0.140		0.119	0.121	.121	.121		
O	0.540	0.560		0.545	0.546	.547	.547		
P	0.490	0.510		0.501	.500	.500	.500		
Q	3.715	3.725		3.717	3.717	3.718	3.719		
R	2.470	2.510		2.492	2.493	2.493	2.493		
S	0.240	0.270		0.255	0.254	.255	.255		
T	0.100	0.180		0.140	0.140	.140	.140		
U	1.625	1.635		1.629	1.628	1.629	1.629		
V	1.362	1.372		1.368	1.366	1.367	1.367		
W	0.316	0.321		0.319	0.319	.318	.318		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585		1.573	1.574	1.573	1.574		
Z	0.178	0.198		0.188	0.188	0.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>JKL</i> / <i>SD</i>	Audited by:	<i>JL</i>
Date:	07/07/04 / 07.07.05	Date:	07/07/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JKL</i>	<i>JKL</i>

DART AEROSPACE LTD				Work Order:	33032
Description: 206 Saddle, Outboard, Left side				Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.127	.128	.127	.127		
B	0.100	0.140		.128	.127	.127	.127		
C	0.100	0.140		.128	.126	.125	.127		
D	0.210	0.230		.225	.225	.224	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.576	1.577	1.577	1.577		
J	2.495	2.505		2.501	2.495	2.500	2.498		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.122	.122	.122	.122		
O	0.540	0.560		.547	.547	.547	.545		
P	0.490	0.510		.497	.498	.497	.496		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.484	2.494	3.414	2.484		
S	0.240	0.270		.256	.255	.253	.256		
T	0.100	0.180		.140	.150	.140	.140		
U	1.625	1.635		1.625	1.627	1.625	1.629		
V	1.362	1.372		1.367	1.367	1.366	1.366		
W	0.316	0.321		.318	.318	.318	.318		
X	1.125	1.145		1.137	1.138	1.137	1.138		
Y	1.565	1.585		1.571	1.571	1.571	1.572		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
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AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>SD</i>	Audited by:	<i>JJ</i>
Date:	07.07.05	Date:	07/07/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690.	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JLM</i>	<i>JLM</i>

